

Work Order ID 86286

86286

Page 1

June-26-12 3:05:32 PM

Item ID: D3243-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 26/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3243 | Rev A | | | | | | | | |
| 110 | HAAS CNC VERTICAL MACHINING #1 | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg | | | | | | | | |
| <u>6061.063</u> | Dwg Rev: <u>A</u> | | | | | | | | |
| | Prog Rev: <u>A</u> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

18 12-6-27

18 12-6-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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8

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Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

[illegible]

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8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | 8 | | | NG 12.7.10 |
| Hand Finishing | | | | | | | | | |
| 180 | | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| Small Fab | Small Fab | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| Small Fab | Install Inserts as per Dwg D3343 | | | | | | | | |
| 190 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | 826/10 |
| Quality Control | | | | | | | | | |

(X8)

| W/O: | | WORK ORDER CHANGES | | | | | |
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June-26-12 3:05:32 PM

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NS1

Revision ID:

Item Name: Bracket Assembly

Stop

NS2

Start Date: 26/06/2012 Start Qty: 8.00

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Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

200

Powdercoat

Powder Coating

Memo

*****Mask Holes*****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50
3200 F
2:20

8X ✓ 12/07/11

210

QC3- Inspect Part Finish

0.00

210

QC

Quality Control

Memo

0.00

8x 4 12/07/11

220

Identify as per dwg & Stock Location: 227

0.00

220

Packaging

Packaging

Memo

0.00

8 12/7/13

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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June-26-12 3:05:32 PM

Item ID: D3243-041

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Revision ID:

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Item Name: Bracket Assembly

Start Date: 26/06/2012 Start Qty: 8.00

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Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 8.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

MLJ 12/07/13

MLJ 12/07/13

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NOTE: Date & initial all entries

Picklist Print

June-26-12 3:05:36 PM

Page 1

Work Order ID: 86286

86286

Parent Item: D3243-041

D3243-041

Parent Item Name: Bracket Assembly

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 05-11-29 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.063 | | Purchased | No | | | 110 | sf | 530.5868 | 0.5499 | 4.630737 | 5 | | |

M6061T6S 063

6061-T6 .063 Sheet

**

B12-6-27

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT021 | 530.5868320 | |
| 113608 | 0 | |
| 116308 | 5.01556842 | |
| 117285 | 67.544 | |
| 119331 | 44.2 | |
| 119802 | 5.94 | |
| 120218 | 17.31 | |
| 120866 | 64.8126316 | |
| 121805 | 325.764632 | |

FE-032-EF

Purchased

No

180 Each

250.0000

4

32

FF-032-FF

Inserts

**

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST285 | 250 | |
| 110836 | 14 | |
| 117168 | 136 | |
| 117226 | 100 | |

121805
32
12/07/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

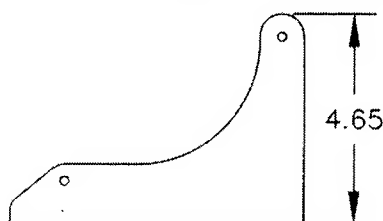
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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|----------------------|-----------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CP</i> | APPROVED <i>CP</i> | DRAWING NO. D3243 | REV. A SHEET 1 OF 1 |
| DATE 04.01.09 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.01.09 | NEW ISSUE | |



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75^{+0.030}
0.000

NO. 86286-MC
12/06/26
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

11.920

11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

1.375

5.273

3.714

0.500

0.000

8.581

8.206

7.706

4.214

R0.25 (TYP)

3.339

R0.38
(TYP)

5.494

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

6.560

5.810

5.360

0.750

0.500

0.000

RELEASED
04.02.03

GRAIN
DIRECTION

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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